

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001634**Date Inspected:** 15-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Fabrication**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Mock Up:

CWI Inspector: Mr. Zhao Chen Sun

Bay 1

QA Inspector observed ZPMC welder Mr. Yuan Fen Chuan stencil 59355 is using welding procedure specification WPS-345-FCAW-1F(1F)-1 Repair-1 using the flux cored welding process for partial penetration groove weld welds on rib weld DP058-001-015. The QA Inspector observed a welding current of approximately 265 amps and 28.2 volts. Items observed by the QA Inspector appear to comply with project specifications.

Bay 7

The QA Inspector observed ZPMC QC ultrasonic inspectors Mr. Xue Hairong and Ms. Shuiqin performing ultrasonic inspections of the following complete penetration joint welds in bay 7: FB018-01-122, FB021-01-122, FB022-01-122, FB017-02-122, FB018-02-0122, FB021-02-122, FB025-02-122. FB018-01-117, FB021-01-117,

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FB022-01-117, FB017-02-117, FB018-02-0117, FB021-02-117 and FB025-02-117. All fourteen welds have been marked as being ultrasonically acceptable.

Bay 3

The Chinese New Year Holiday started on February 07 and due to this event many of the ZPMC employees are not working. Inspector did not observe any personnel welding in bay 3.



Summary of Conversations:

See above for summary of conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul
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Quality Assurance Inspector

Reviewed By:	Cochran,Jim
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QA Reviewer
